

FIG. 1

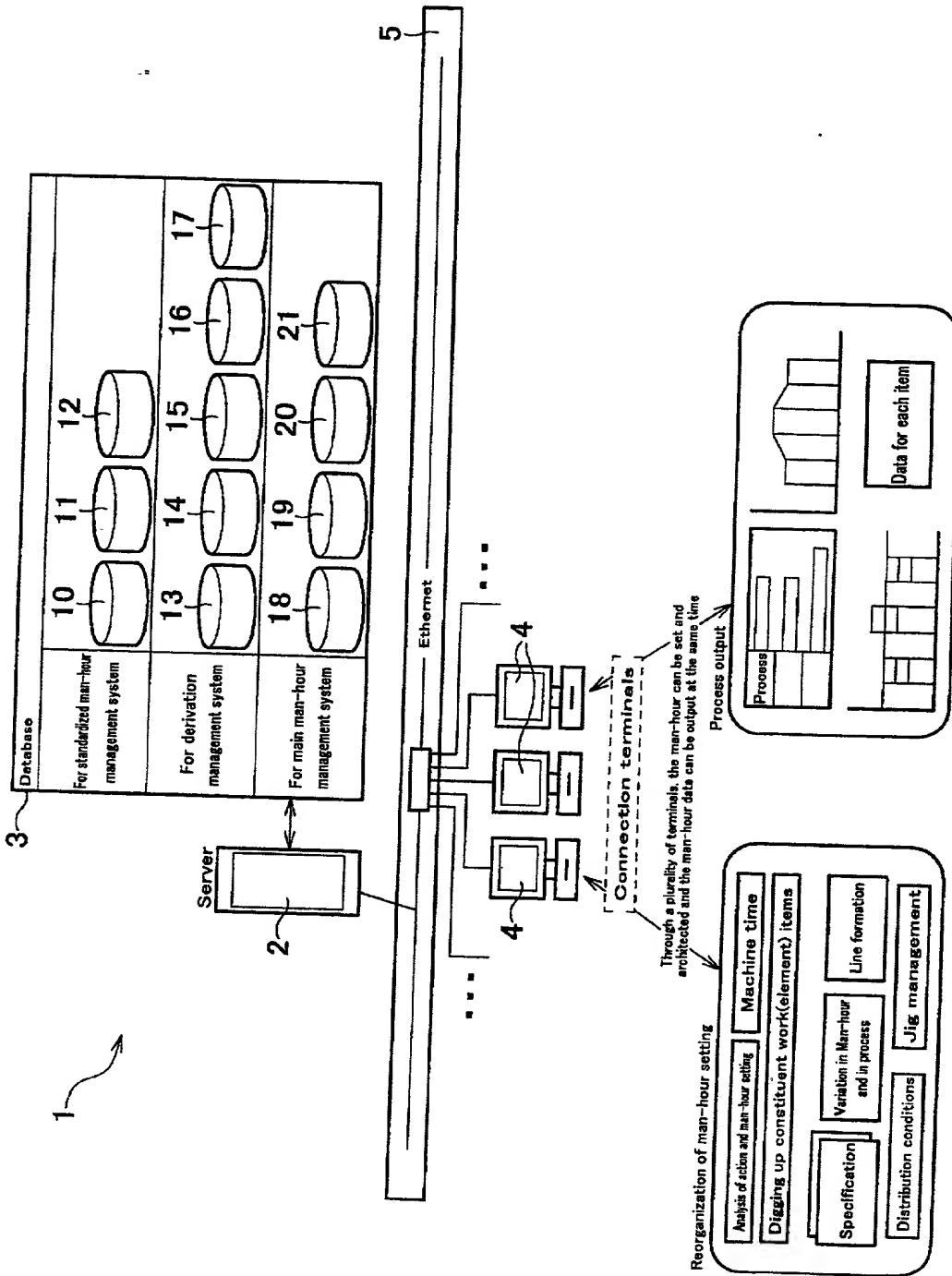
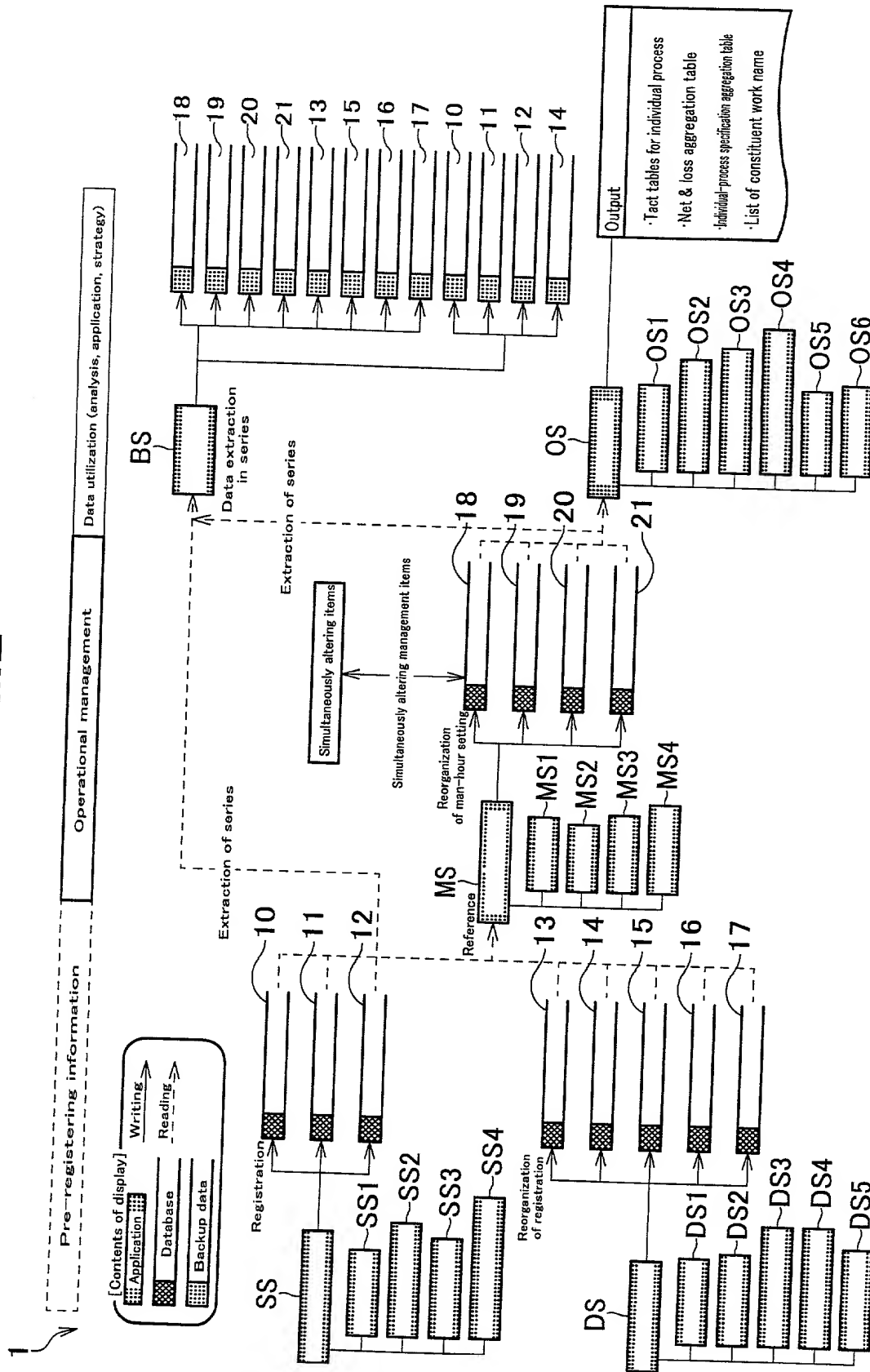


FIG.2



[illegible]

FIG. 4

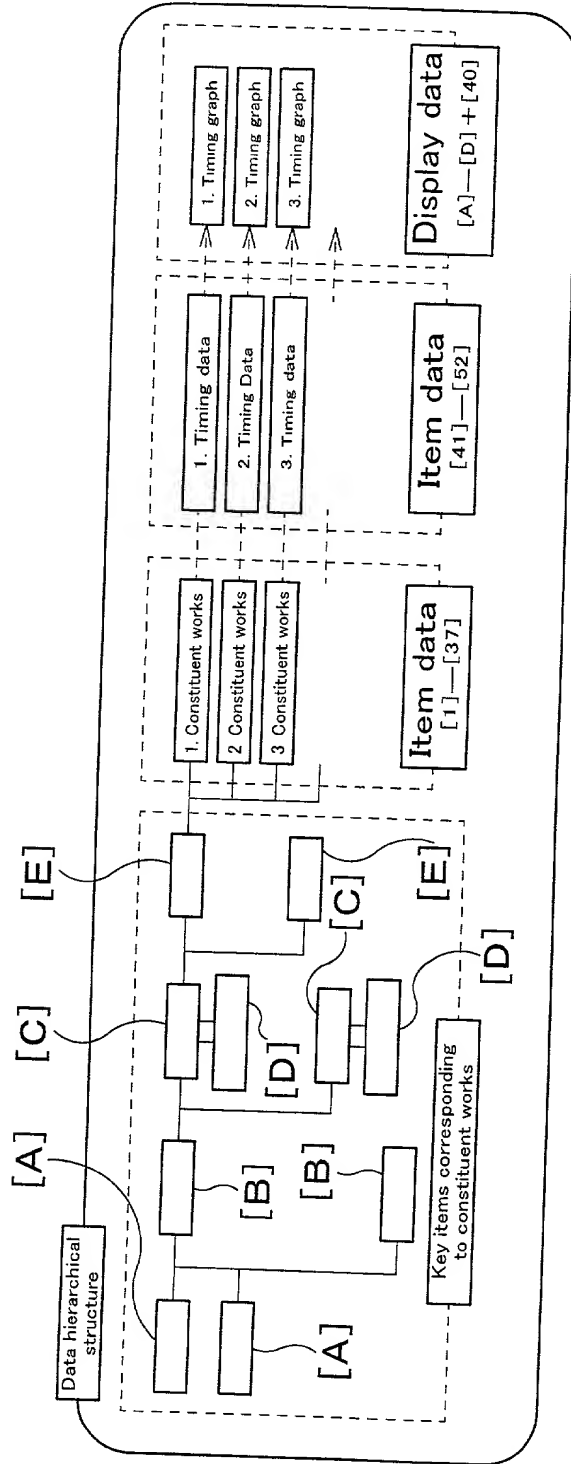


FIG. 5

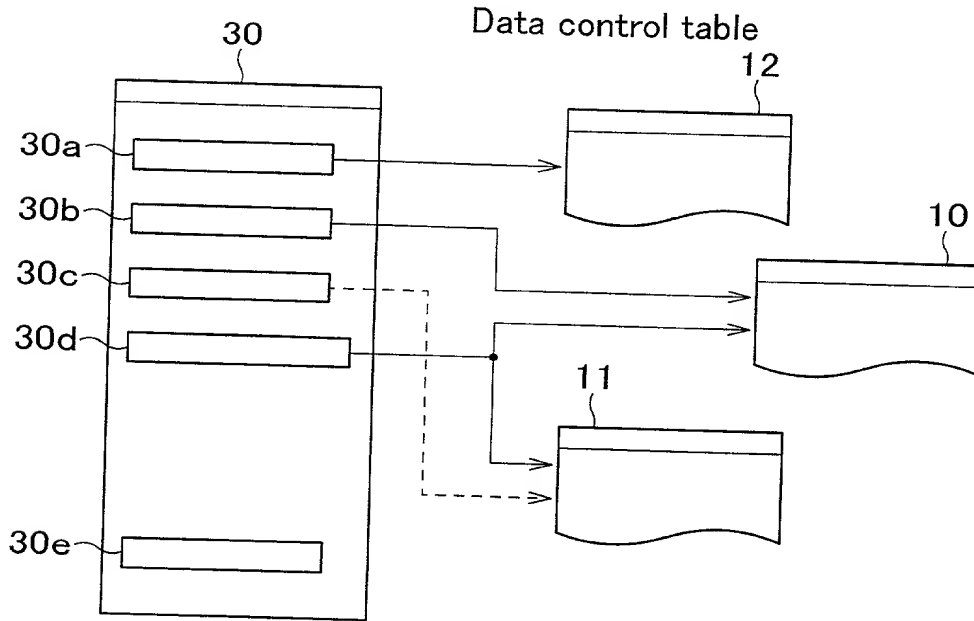


FIG. 6

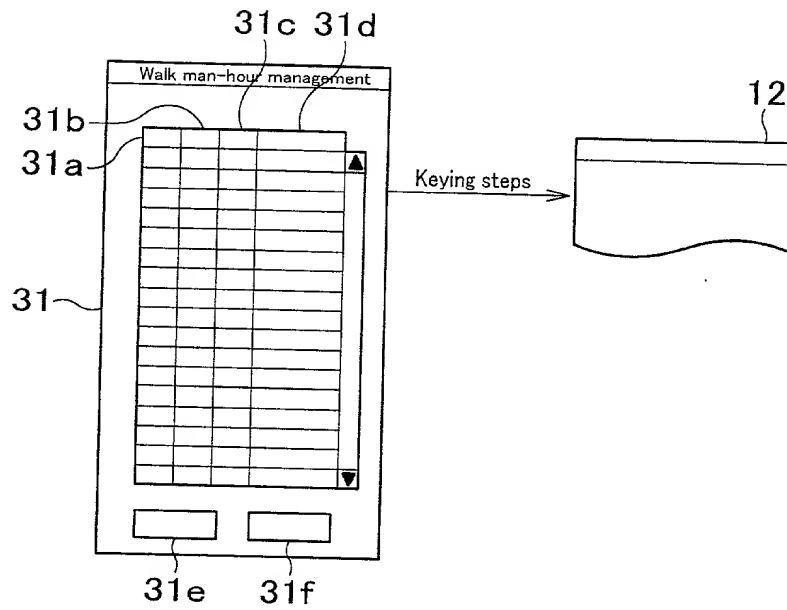


FIG. 7A

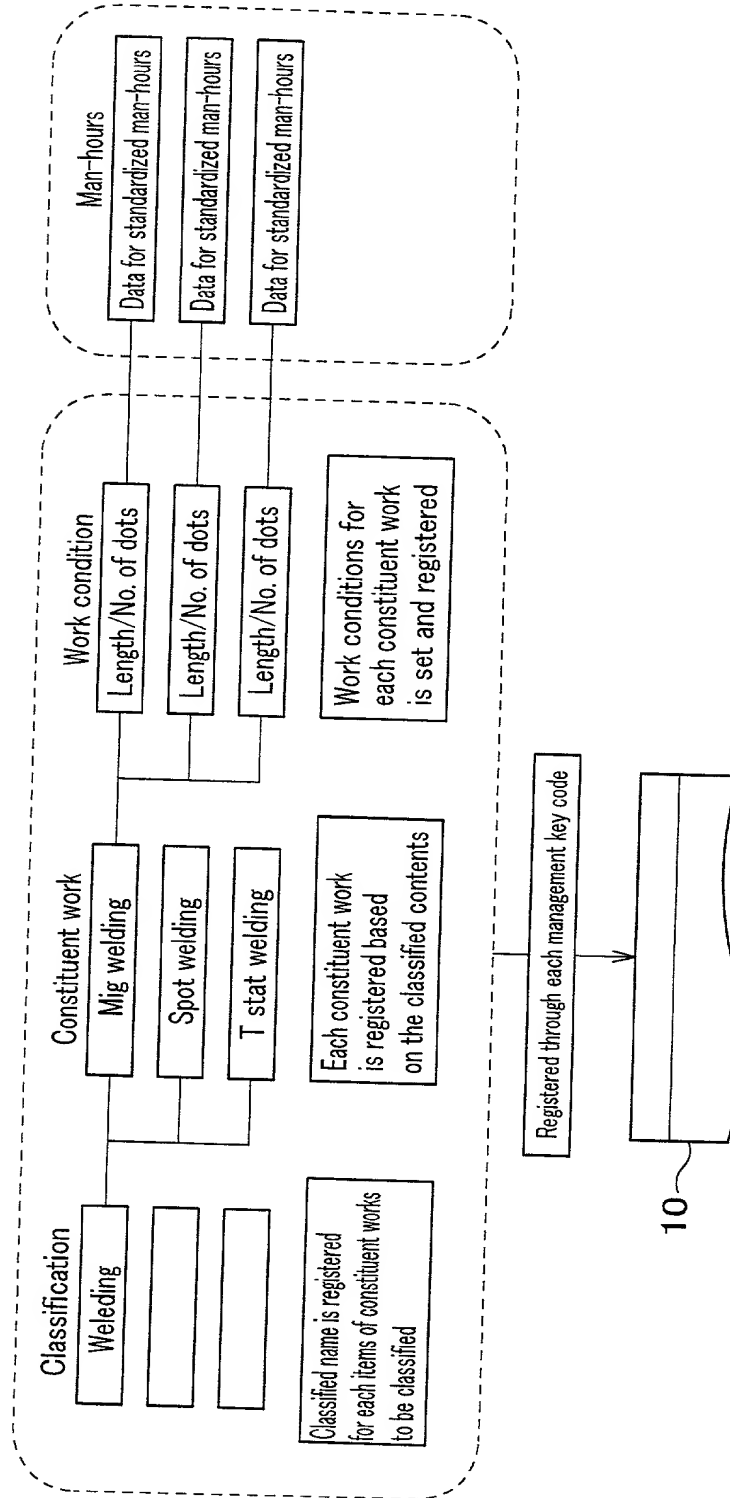


FIG. 7B

Basic setting of constituent work

Edit

Index

Class

Constituent work

Spot welding

Mig welding

T-Stat welding

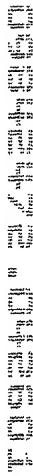
32a1 32a2 32a4 32a5 32a6

32b1 32b2 32b3

32c 32d 32e

32

32a 32b 32c 32d 32e

[illegible]

18



FIG.9A

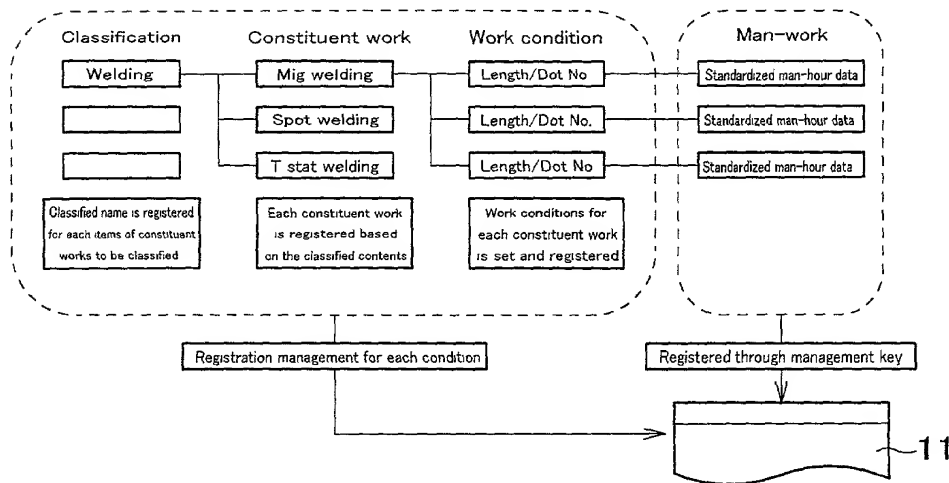


FIG.9B

34d1 34 34d 34e2 34e1 34i 34e

Select item condition of registering stand. man-work

34a Edit

34c1 Class.

34c

Constituent work

Setting work cond.

Length ☒ $\geq 6\text{mm}$ ☐ $\geq 12\text{mm}$ ☐ $\geq 18\text{mm}$

Dot No. ☒ 1 ☐ 2 ☐ 3 ☐ 4

☐ 5 ☐ 6

Display tot. m-work

Display end line of group

34f

34g

34h

34b

Standardized man-work

Remarks

34b18

34b2 34b4 34b6 34b8 34b10 34b12 34b14 34b16

[12]	[13]	[14]	[15]	[16]	[17]	[18]	[19]	[20]	[24]	[25]	[26]	[27]	[28]	[29]	[36]	[37]
------	------	------	------	------	------	------	------	------	------	------	------	------	------	------	------	------

Input standardized man-work data

34b1 34b3 34b5 34b7 34b9 34b11 34b13 34b15 34b17

FIG. 10A

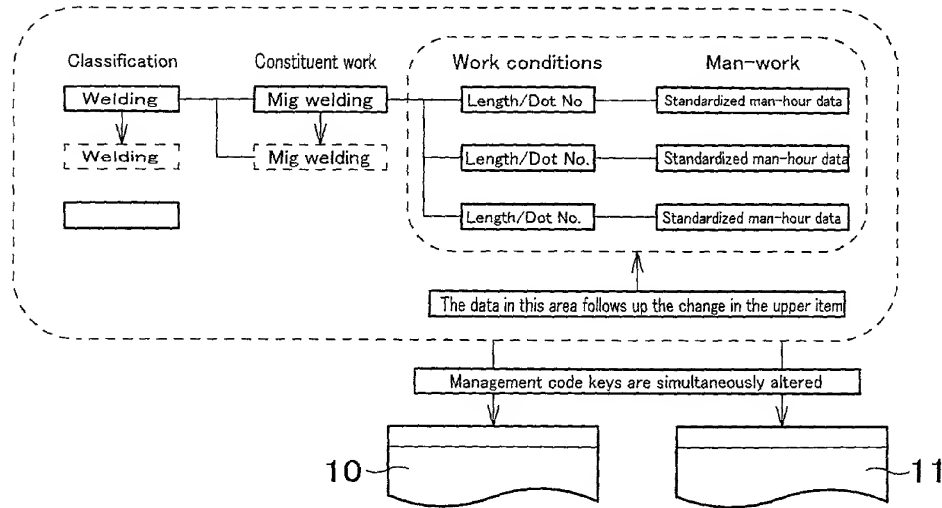


FIG. 10B

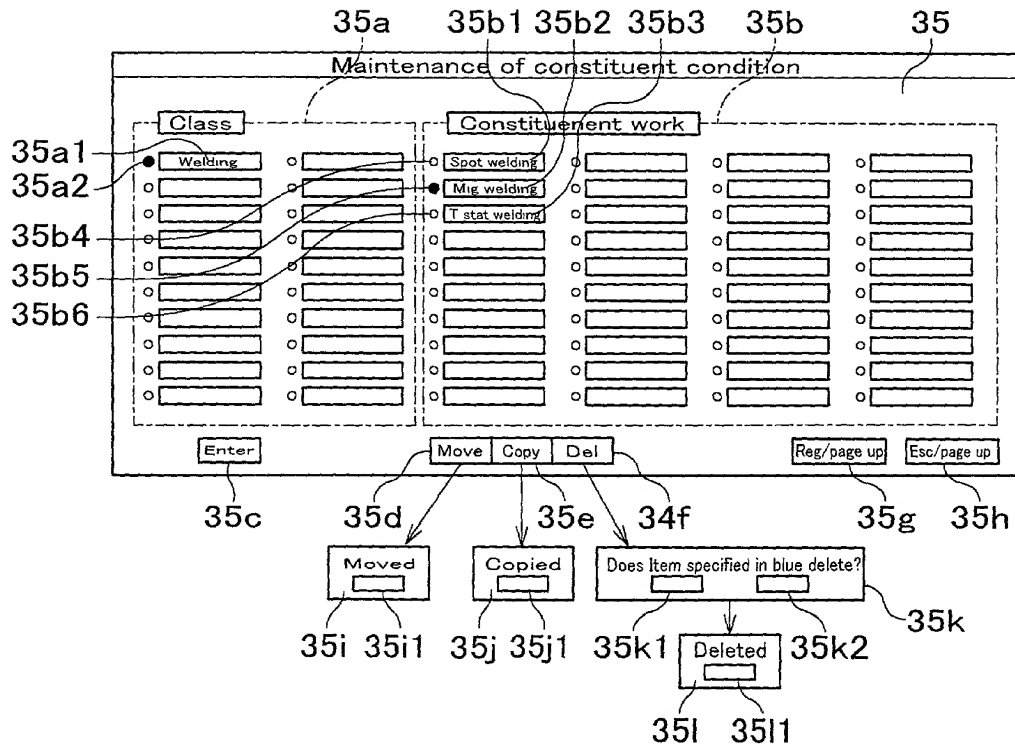
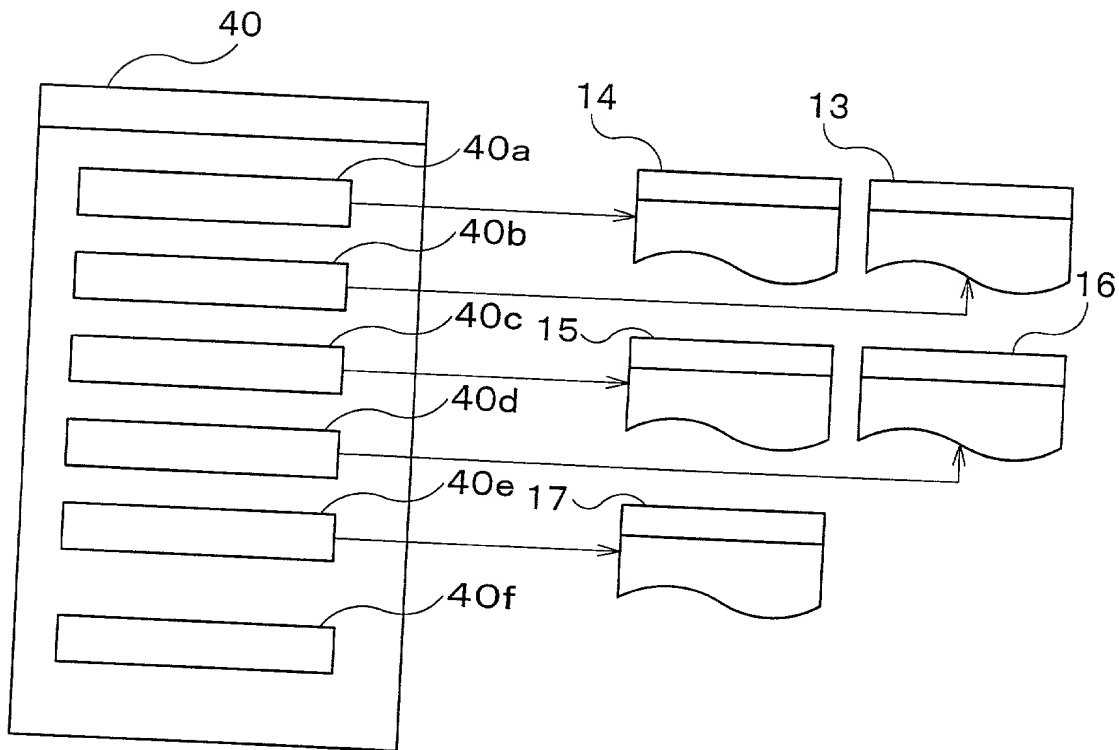


FIG. 11



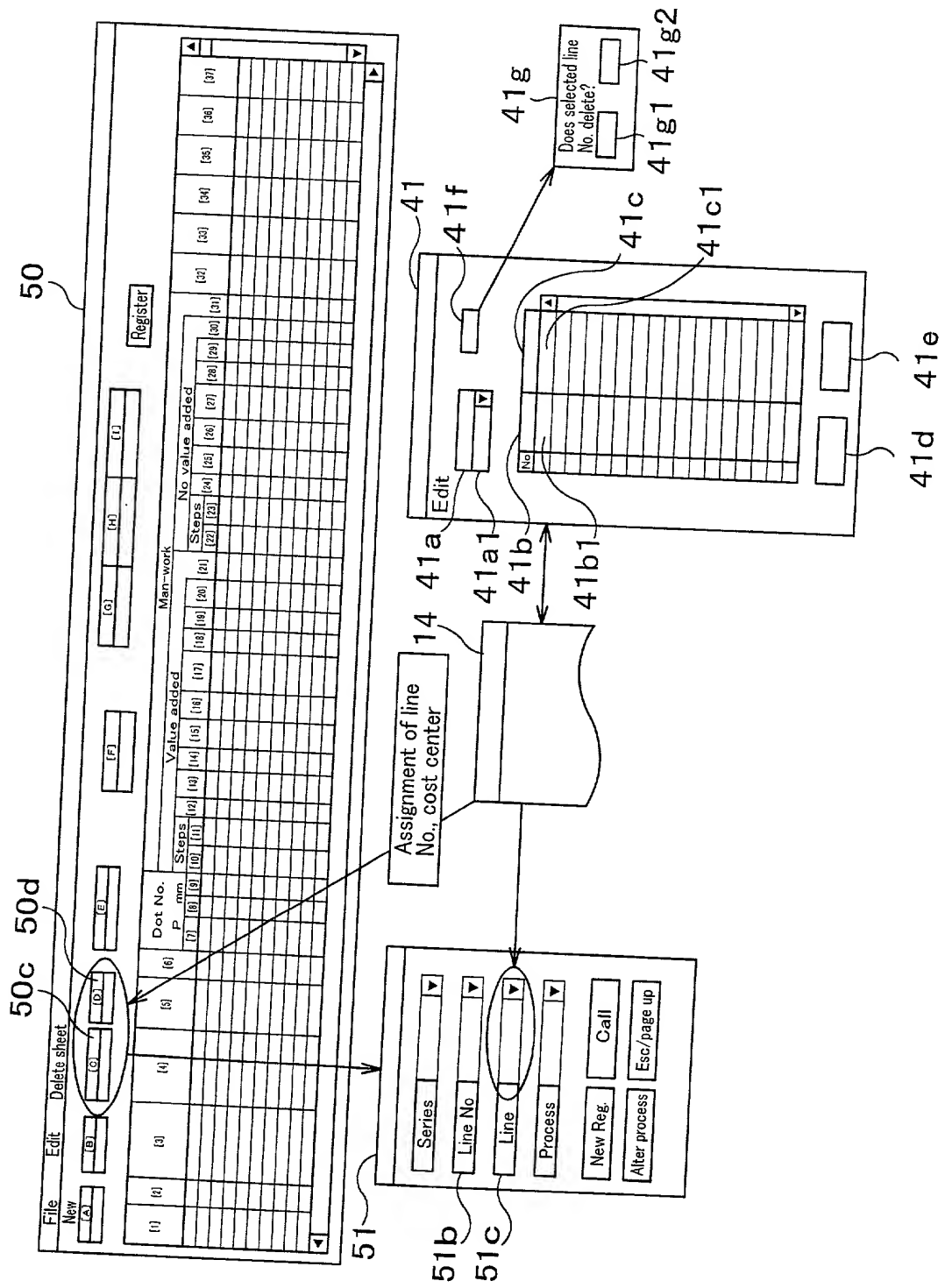


FIG. 12B

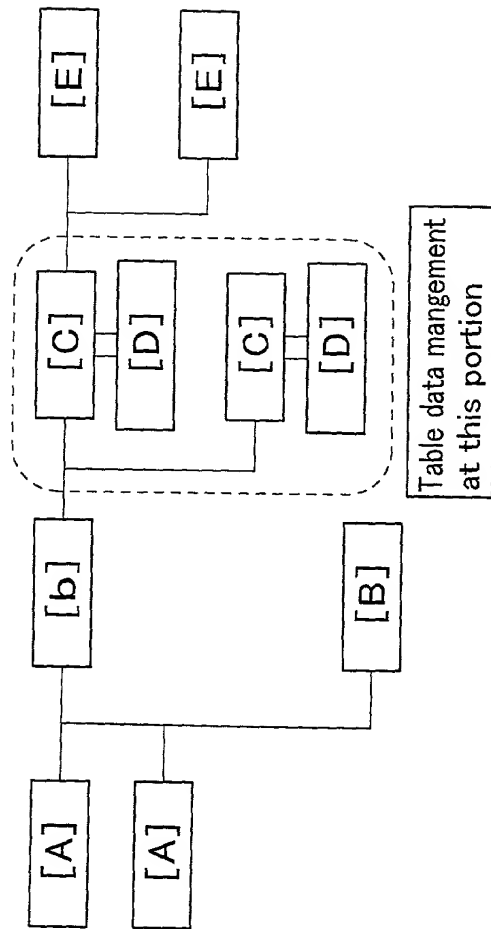


FIG. 13

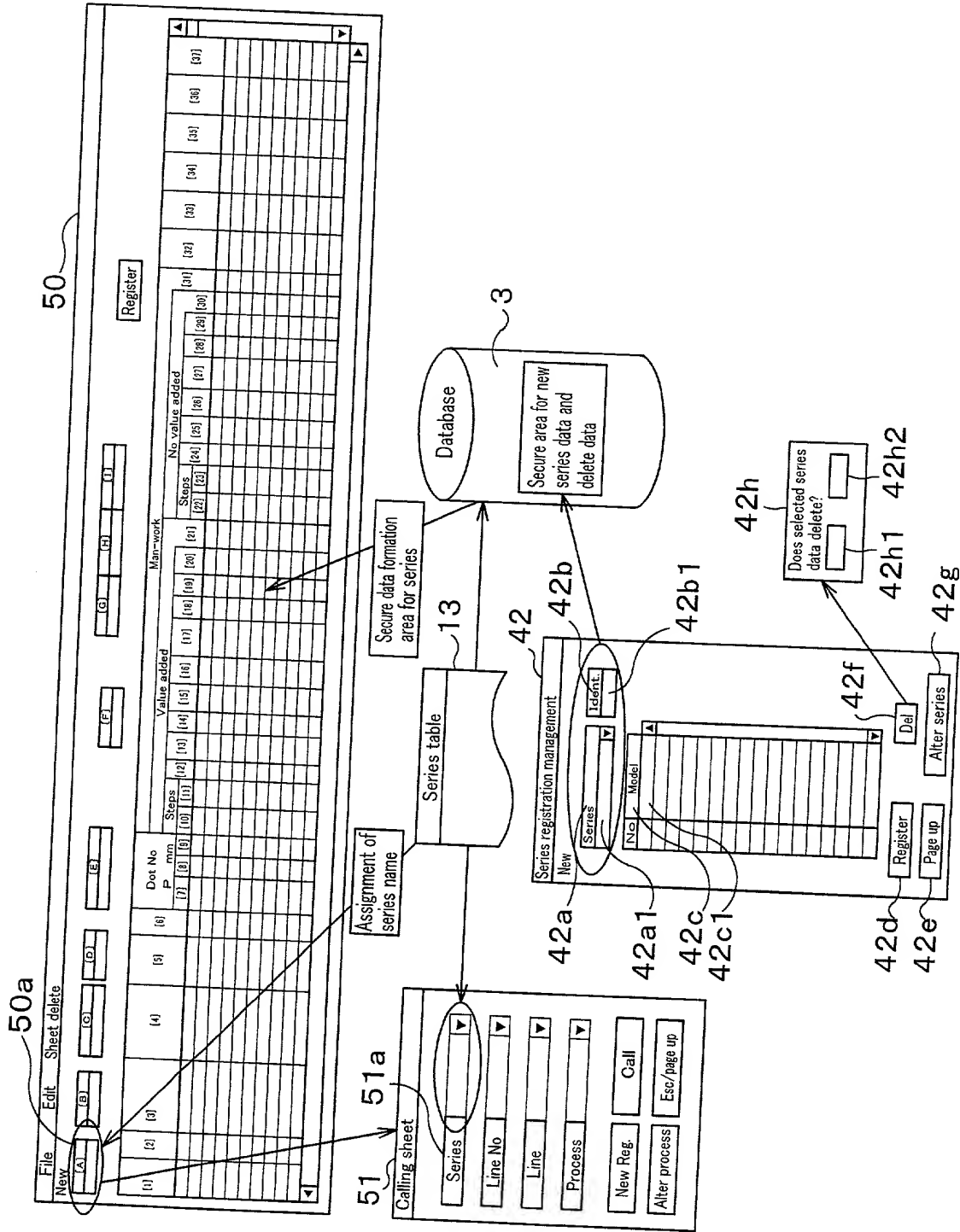


FIG. 14

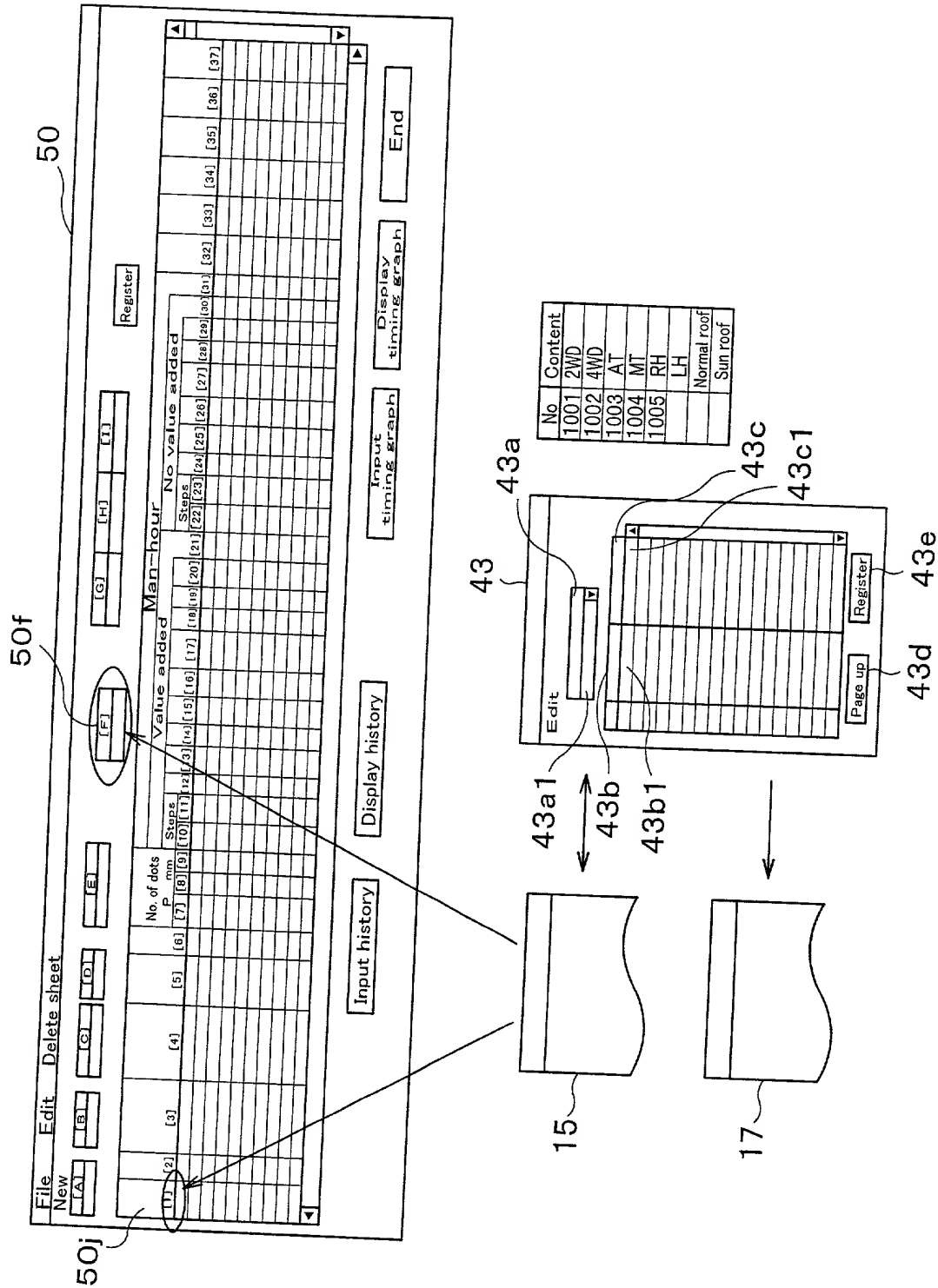


FIG. 15

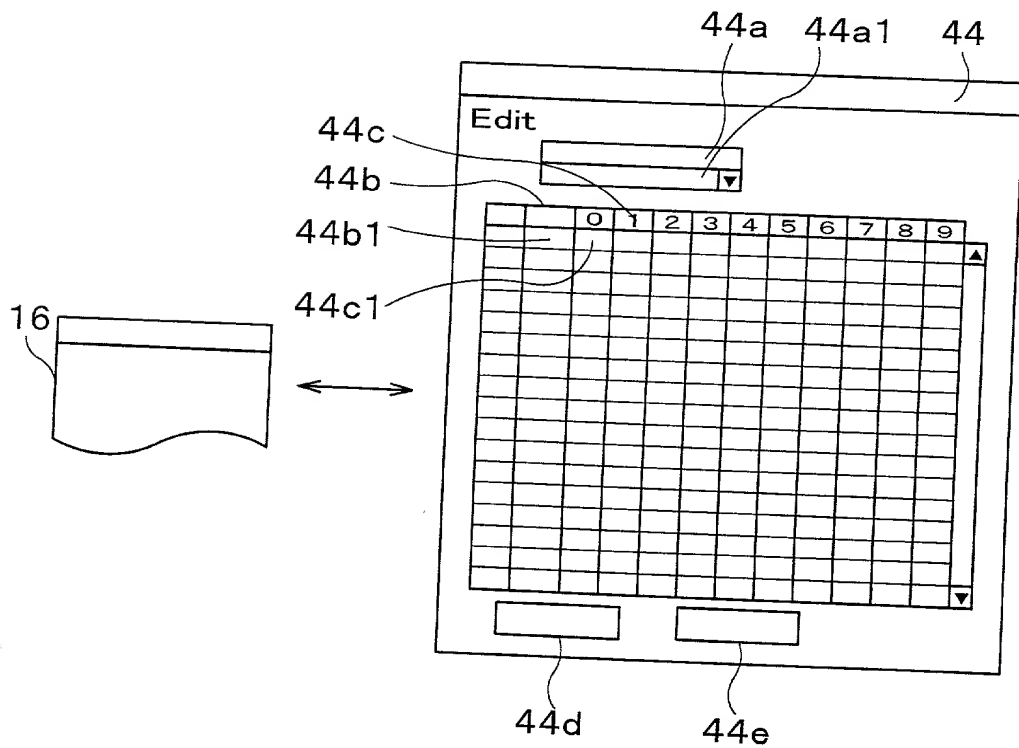


FIG. 16

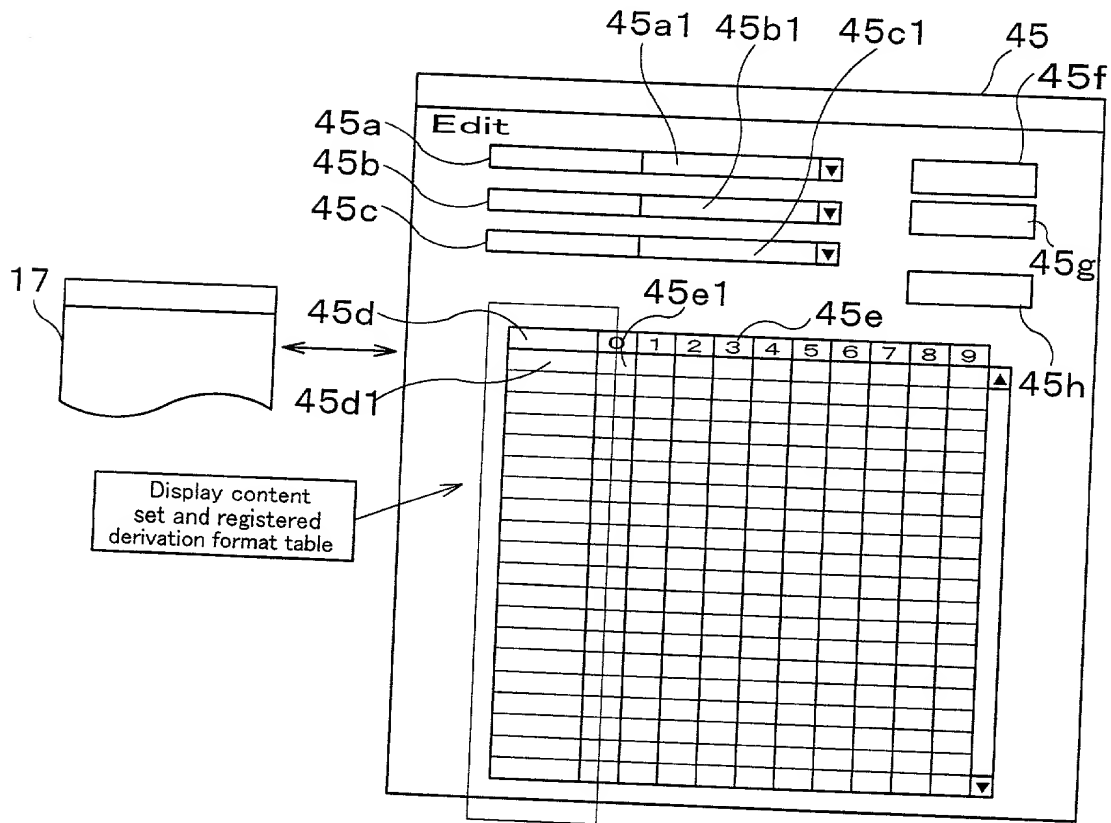


FIG. 17A

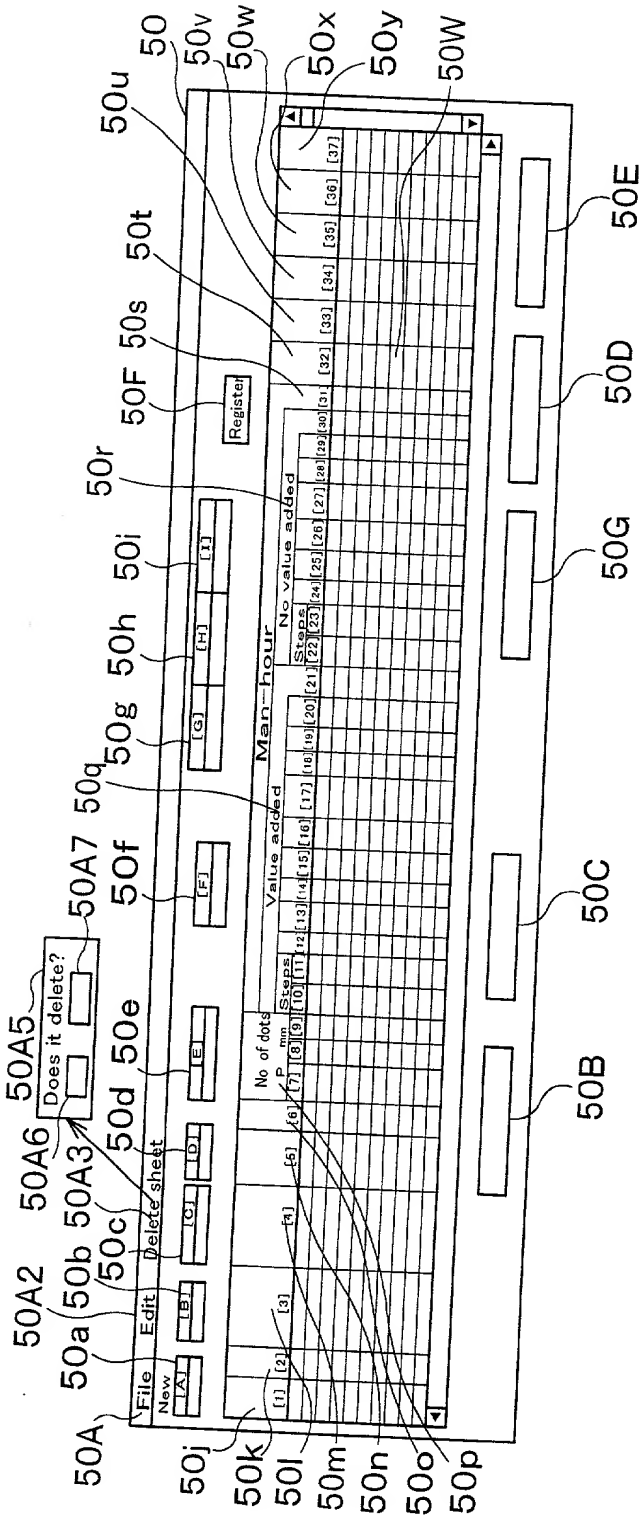
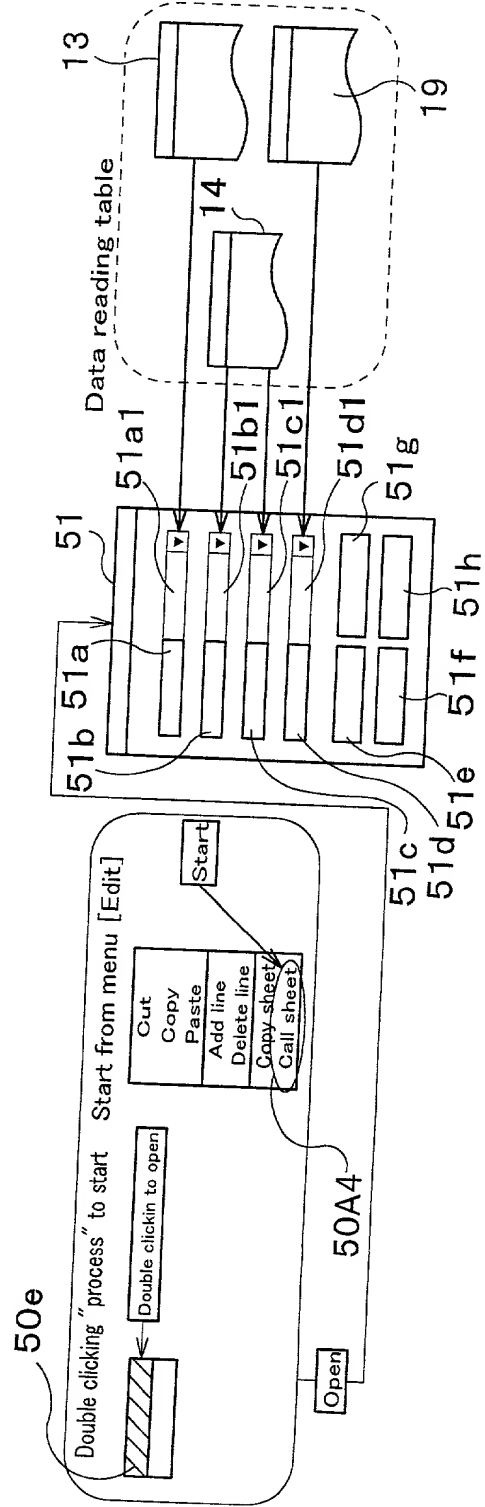


FIG. 17B



05

504

50j

50k

50:1

50W

FIG.18B

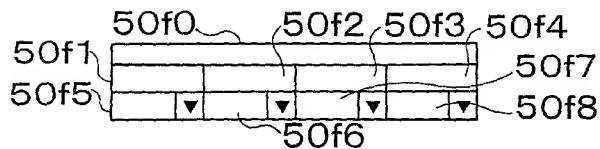


FIG.18C

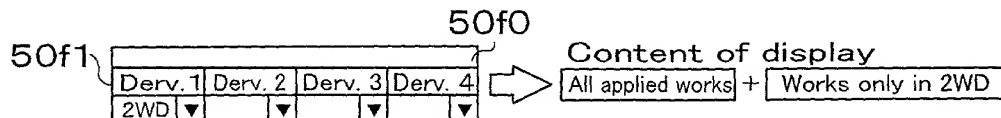


FIG.18D

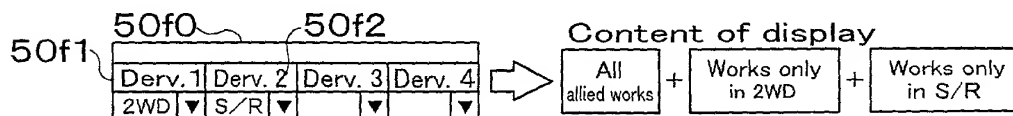


FIG.18E

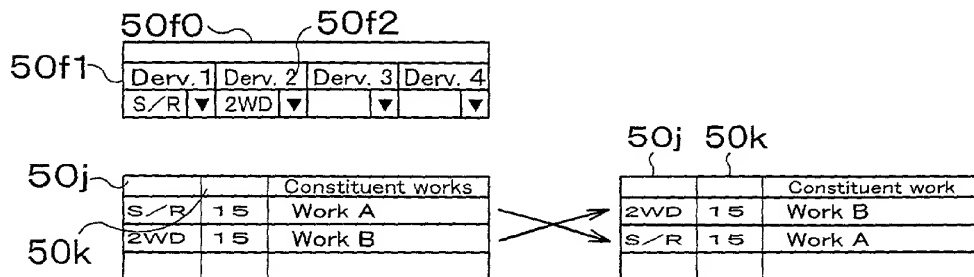


FIG.18F

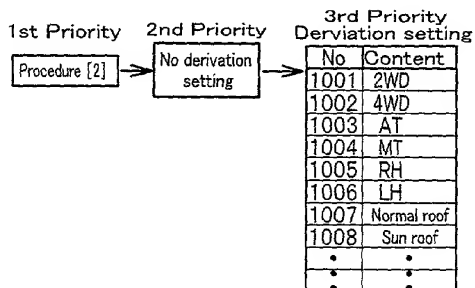


FIG. 19

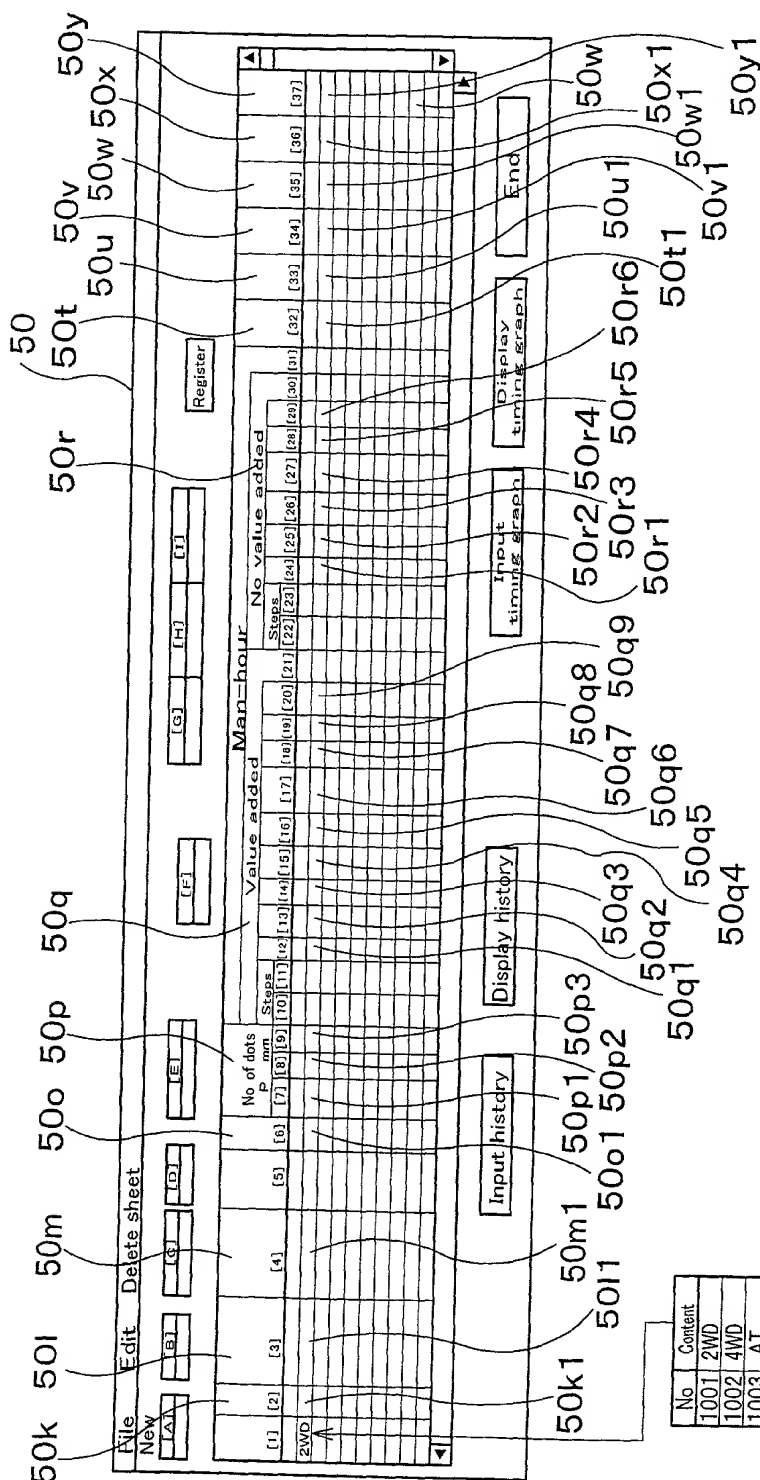


FIG. 20

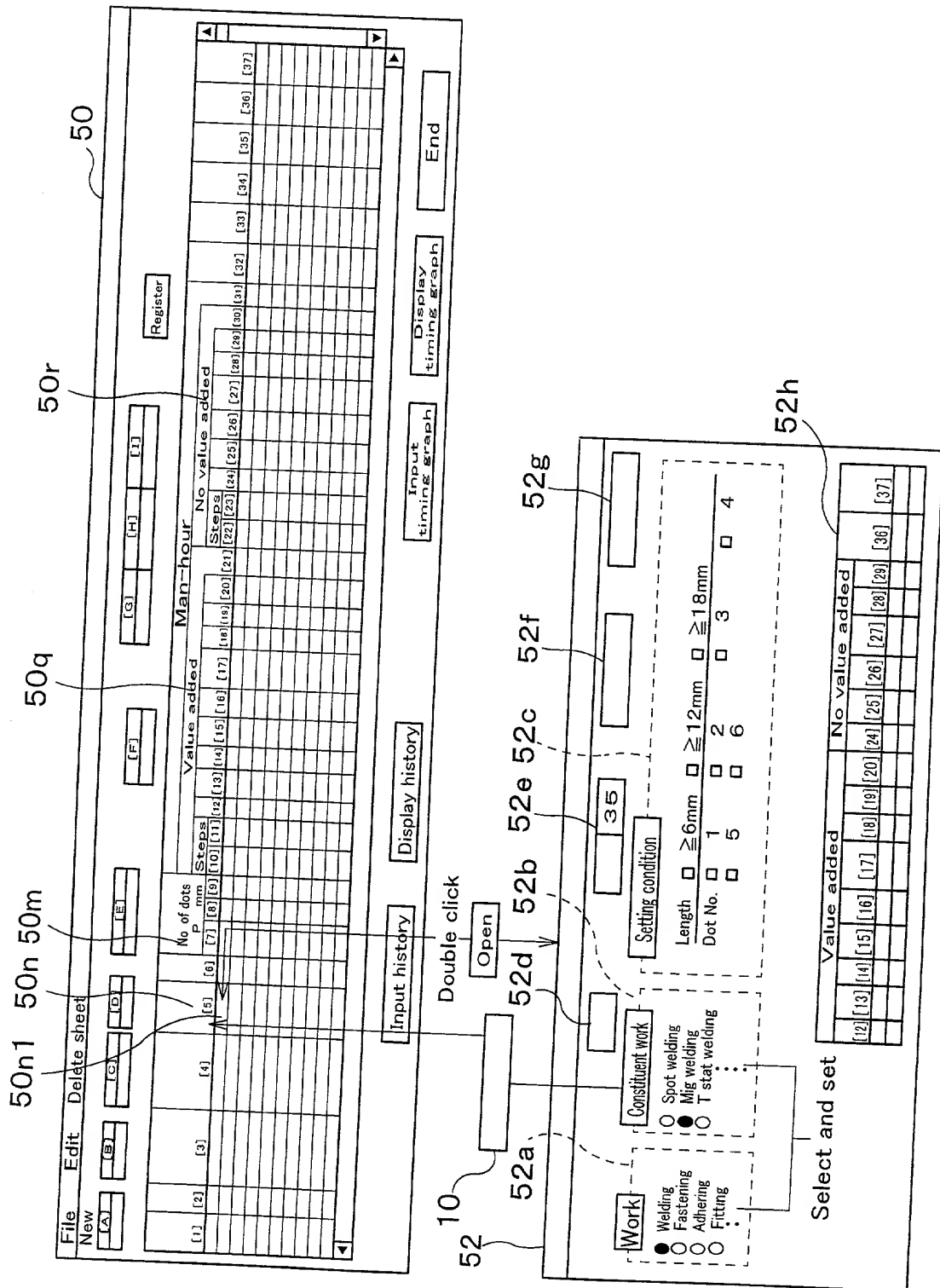


FIG. 21

50r

50

File Edit Delete sheet

New

[A] [B] [C] [D] [E] [F] [G] [H] [I]

Register

Value added

Man-hour

No value added

Steps

Dot No.

P

mm

[1] [2] [3] [4] [5] [6]

[7] [8] [9] [10] [11] [12] [13] [14] [15] [16] [17] [18] [19] [20] [21] [22] [23] [24] [25] [26] [27] [28] [29] [30] [31] [32] [33] [34] [35] [36] [37]

Input history

Display history

Input timing graph

Display timing graph

End

21b 21d 21f 21h 21j

21

ST Wait 1 Ope. 1 Wait 2 Ope. 2 Wait 3 Ope. 3 Wait 4 Ope. 4 Wait 5 Ope. 5 Total

2,5 1,1 2,2

Write the total of wait [1] ~ [5] on wait [29] of main man-work management as a line unit
 *write at storage of timing data in man works

Processing main data
 Subtotal [30] + [31] is re-calculated
 and is required to be written on DB

FIG. 22

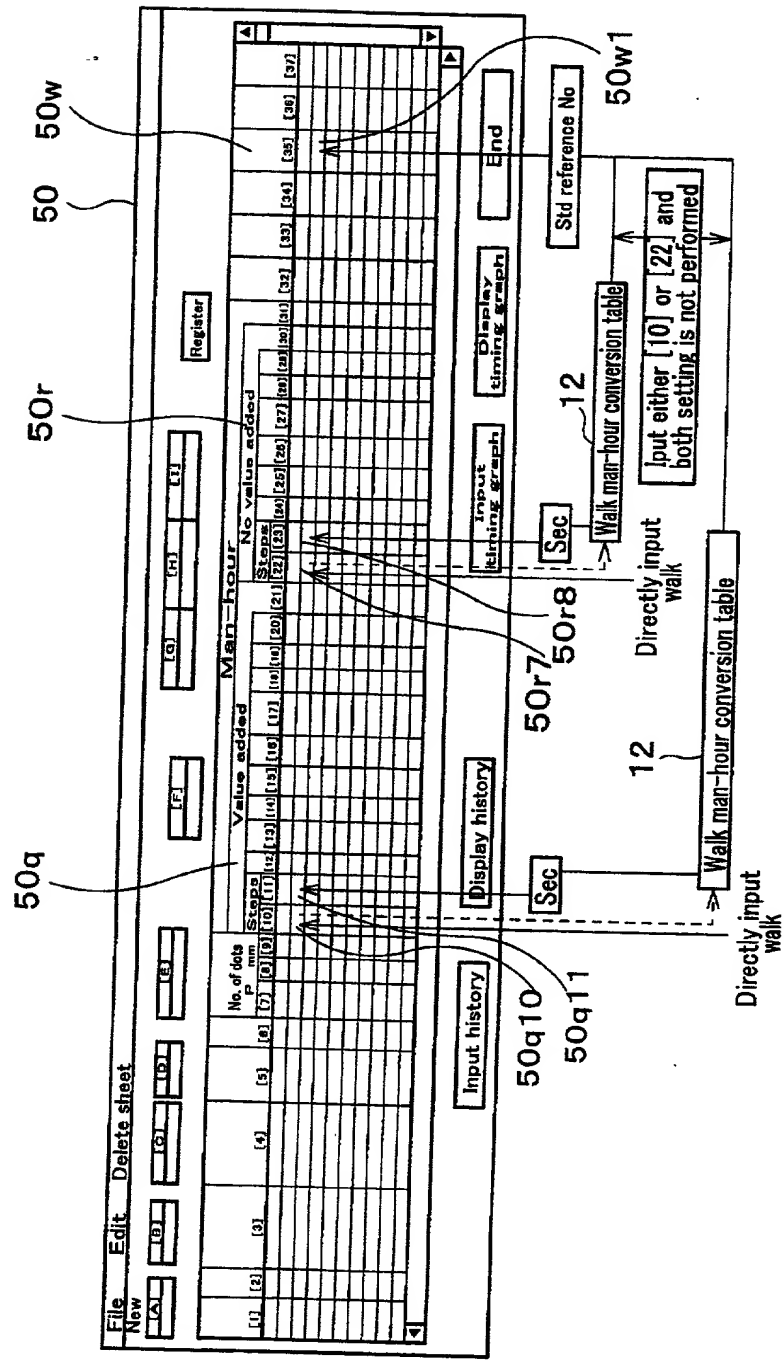


FIG. 23

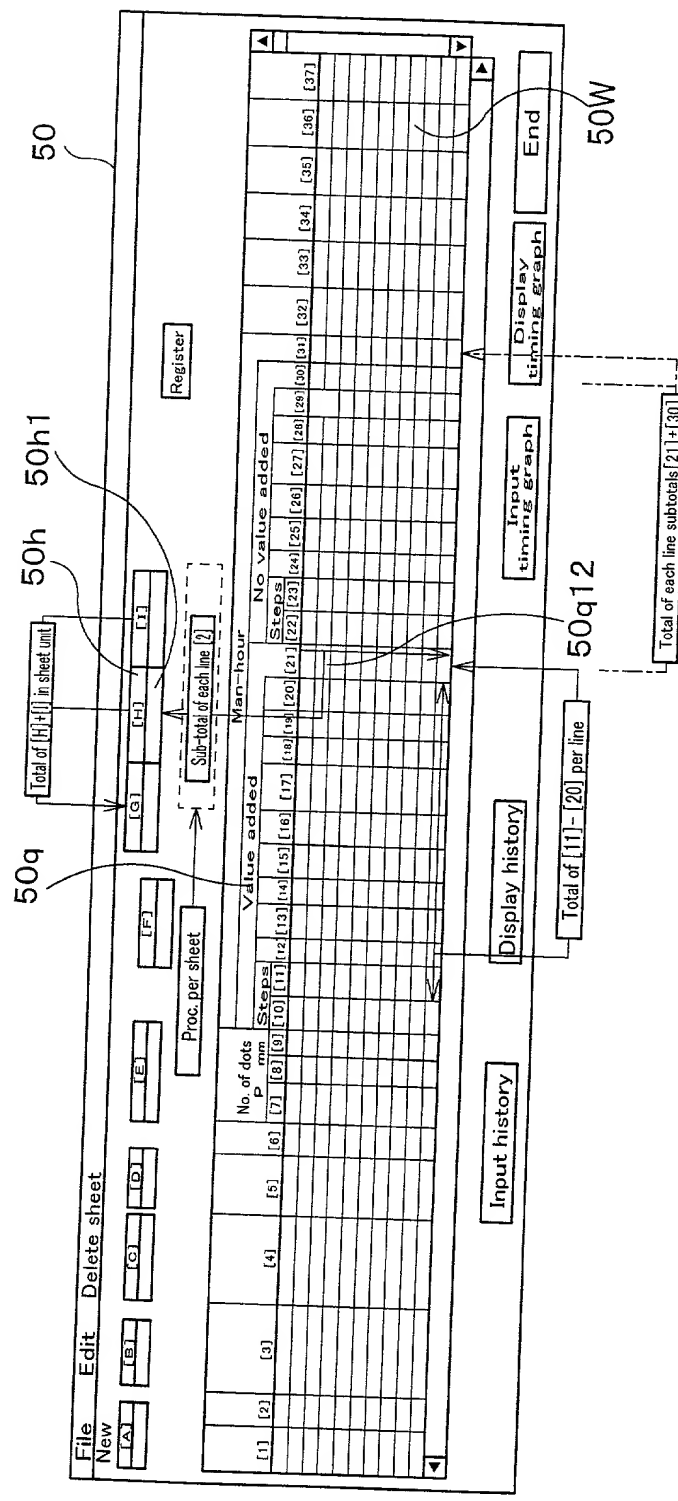


Figure 1 is a schematic diagram of a data processing system. The system includes a menu bar with options: File, Edit, Delete sheet. Below the menu bar is a row of buttons: [A], [B], [C], [D], [E]. A dashed box labeled "Processing in sheet unit" contains a box labeled "Total of [H]+[I] in sheet unit" and a box labeled "Total of subtotal [30] in each line". The main area is a large grid with columns labeled: No of dots, P, mm, Steps, Value added, Man-hour, No value added. The grid is divided into sections: Input history, Display history, Input timing graph, Display timing graph. The grid is labeled with various reference numerals: 50g1, 50g, 50h, 50i, 50r, 50s, 50i1, 50r9, 50s1, 50w. A "Register" block is shown above the grid. An "End" button is at the bottom right. A box labeled "Total of each line [23] to [29]" is shown below the grid. A box labeled "Total of each line subtotal [2] + [30]" is shown at the bottom right.

FIG. 25

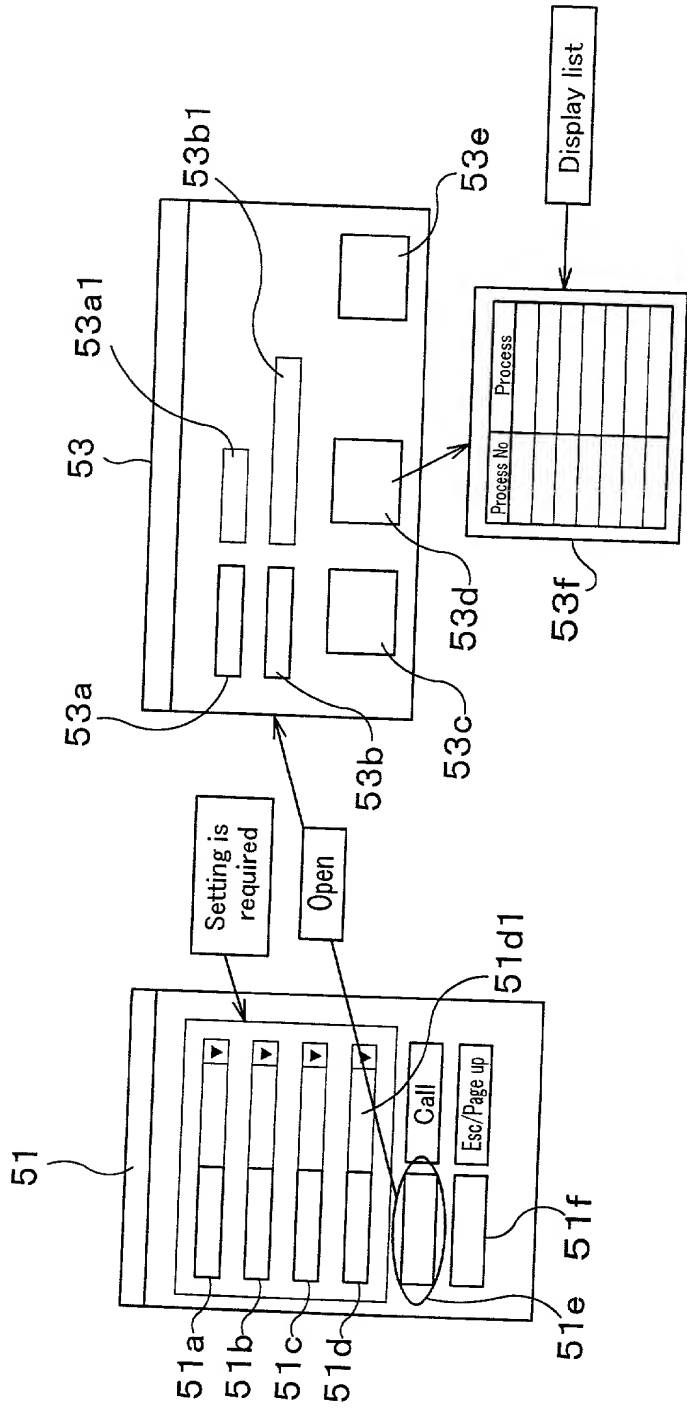


FIG. 27

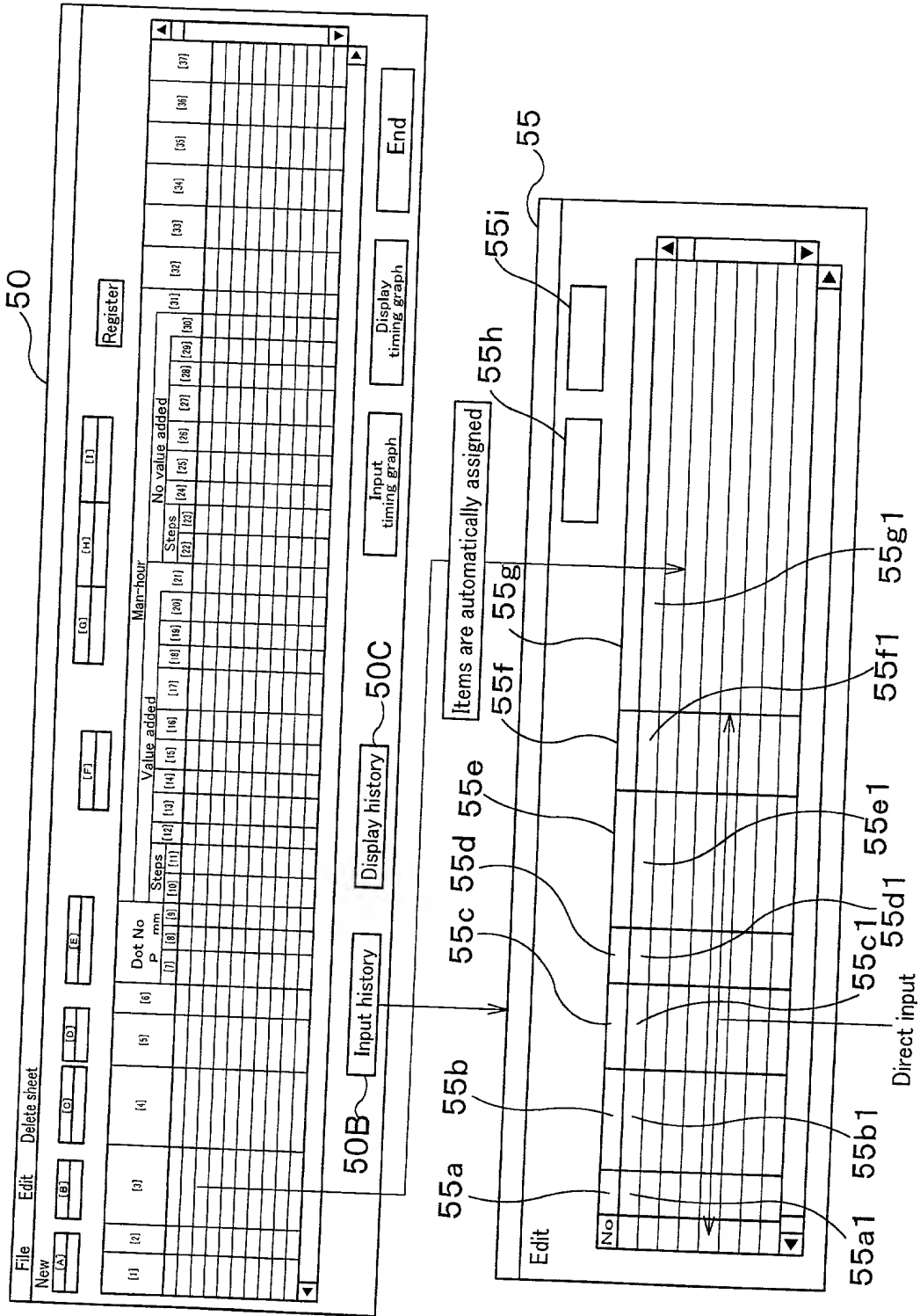


FIG. 28

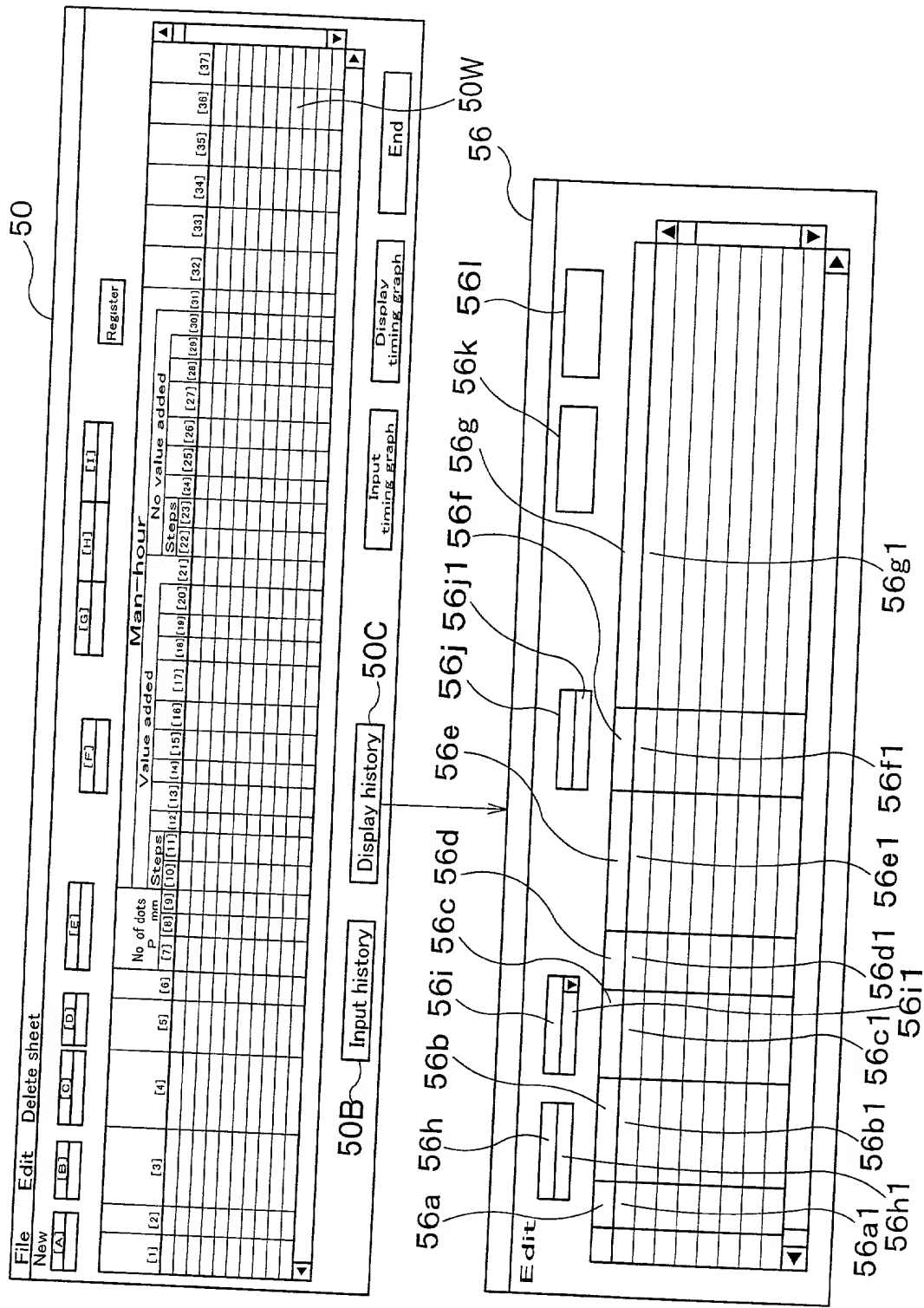


FIG.29A

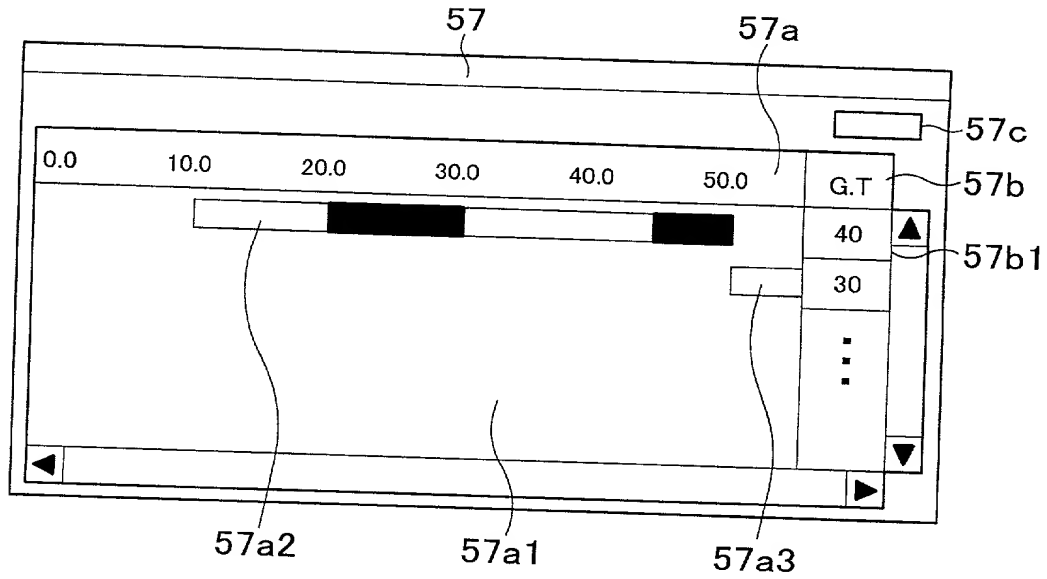


FIG. 29B

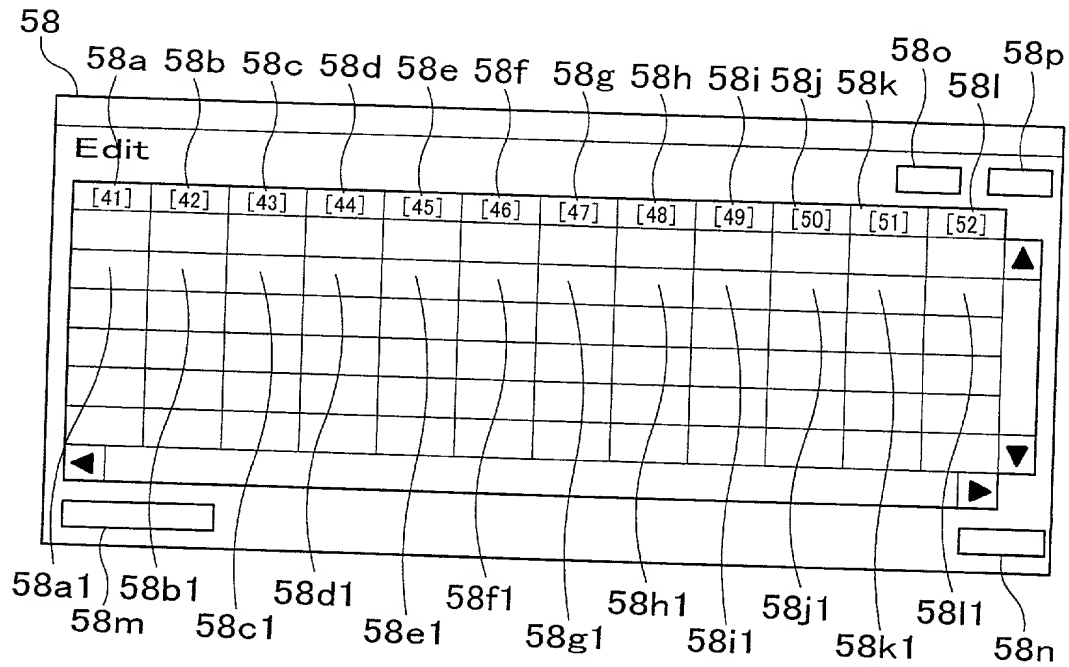


FIG. 30

[illegible]

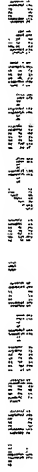
[illegible]

FIG. 33A

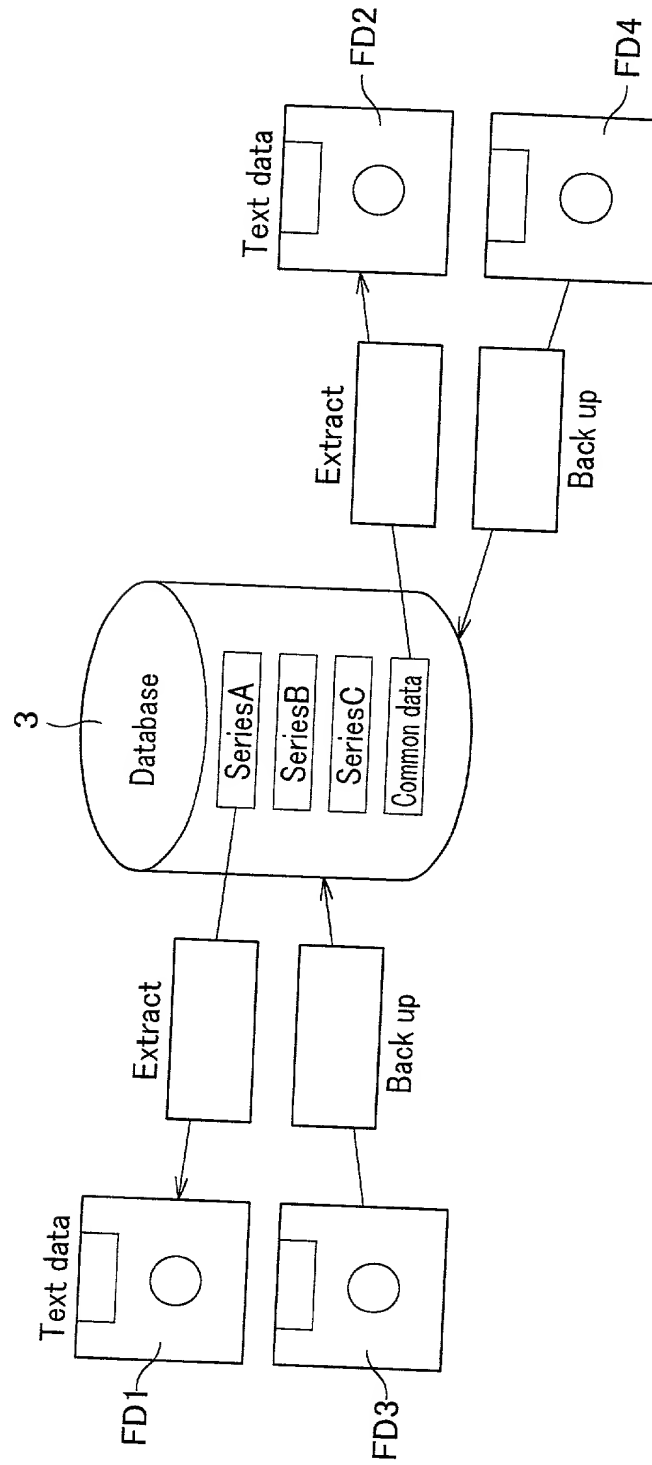


FIG. 33B

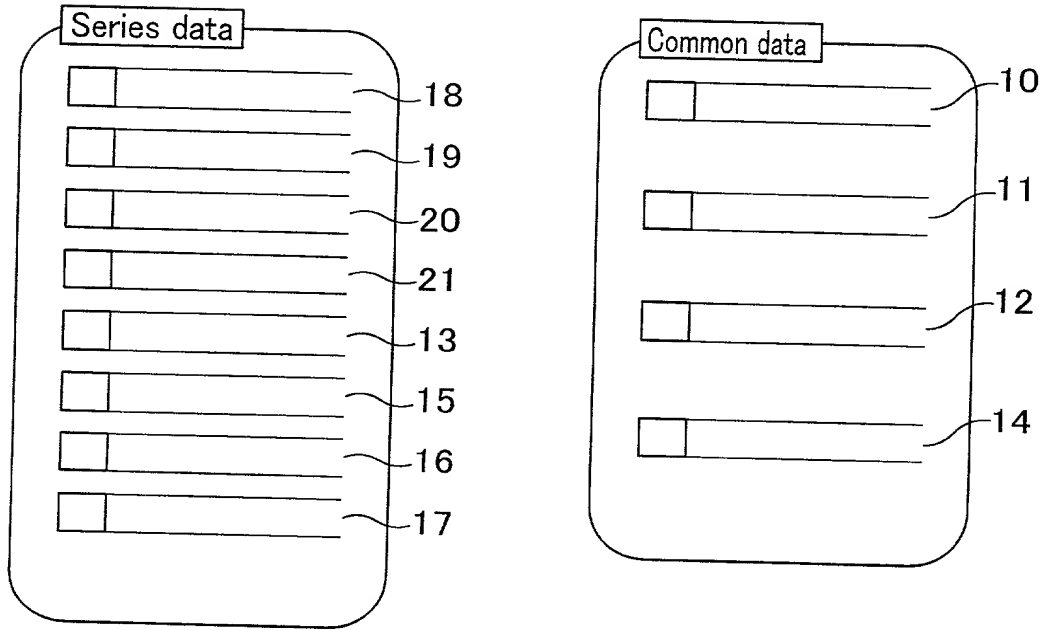


FIG. 34

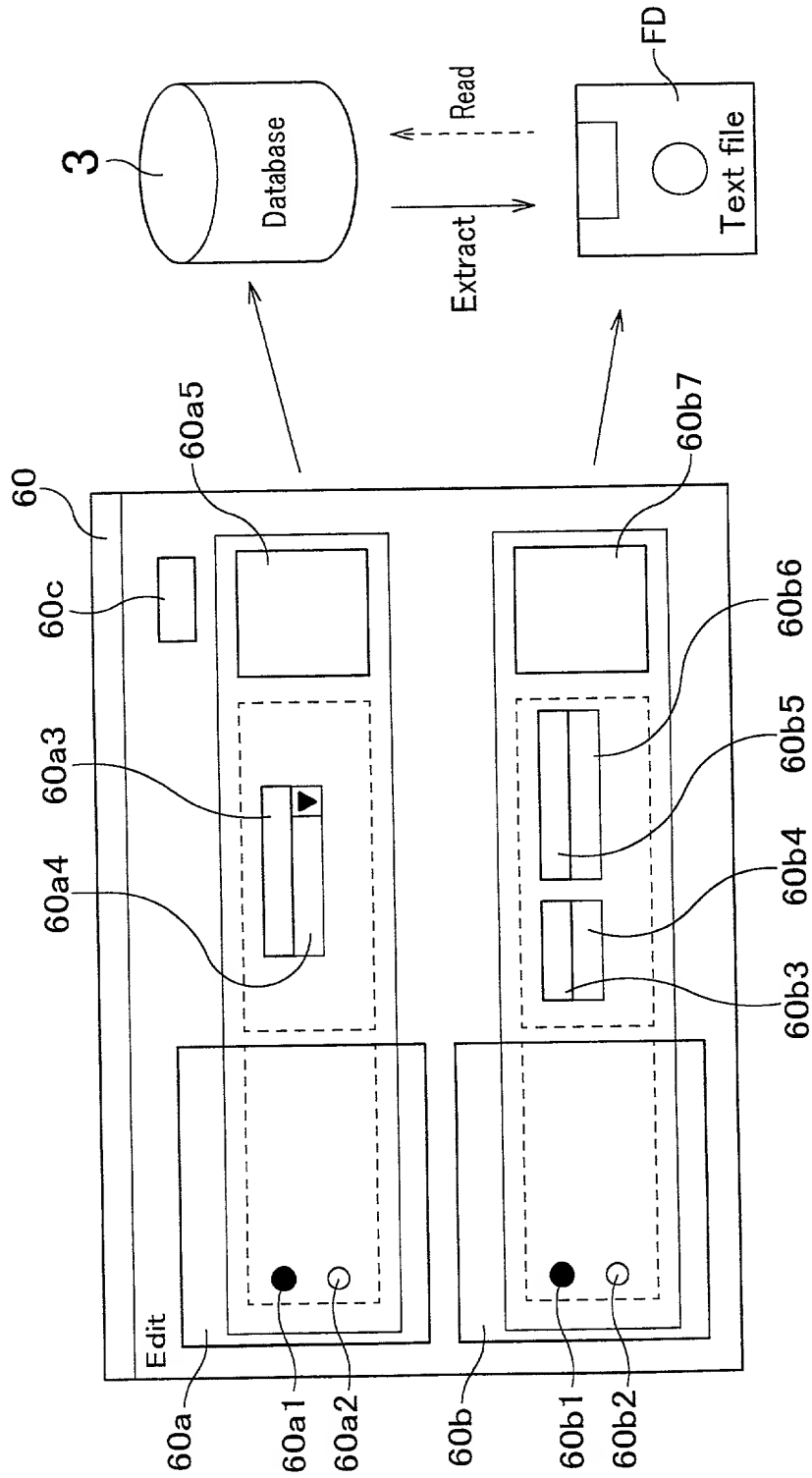


Diagram of a display device 70. It features a stack of six horizontal bars, labeled 70a through 70f from top to bottom. To the right of this stack is a rectangular block labeled 70g. The entire assembly is enclosed within a frame labeled 70.

FIG.37A

72 72a 72a1 72b1 72b 72d

Seriese	No condition				
Line NO.	No condition				
Line name	SP OUT	SP COMP	FR W/H		
Cost sensor	211105	211105	211101		
Process	No condition				
Derivalion	No condition				

1	FRW/H	211101	SET LH	1	Side frame		Off
2				2	Side frame		Out
3				3	Side frame		Turn
4				4	Side frame	T.T M/C	Set
5				5	Clamper		Push button
6				6	Dumper housing		Off
7				7	Dumper housing		Out

72c

FIG. 37B

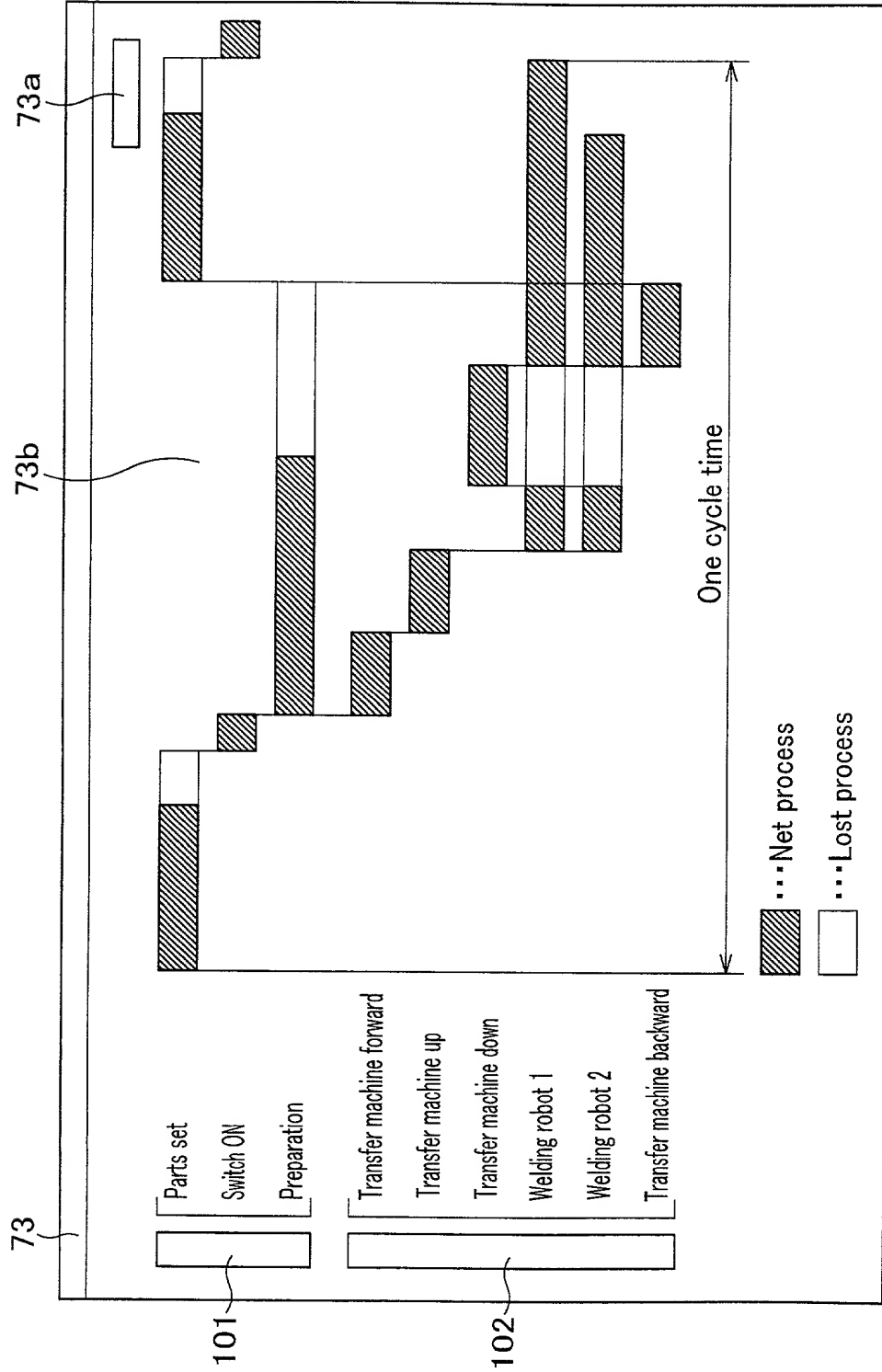
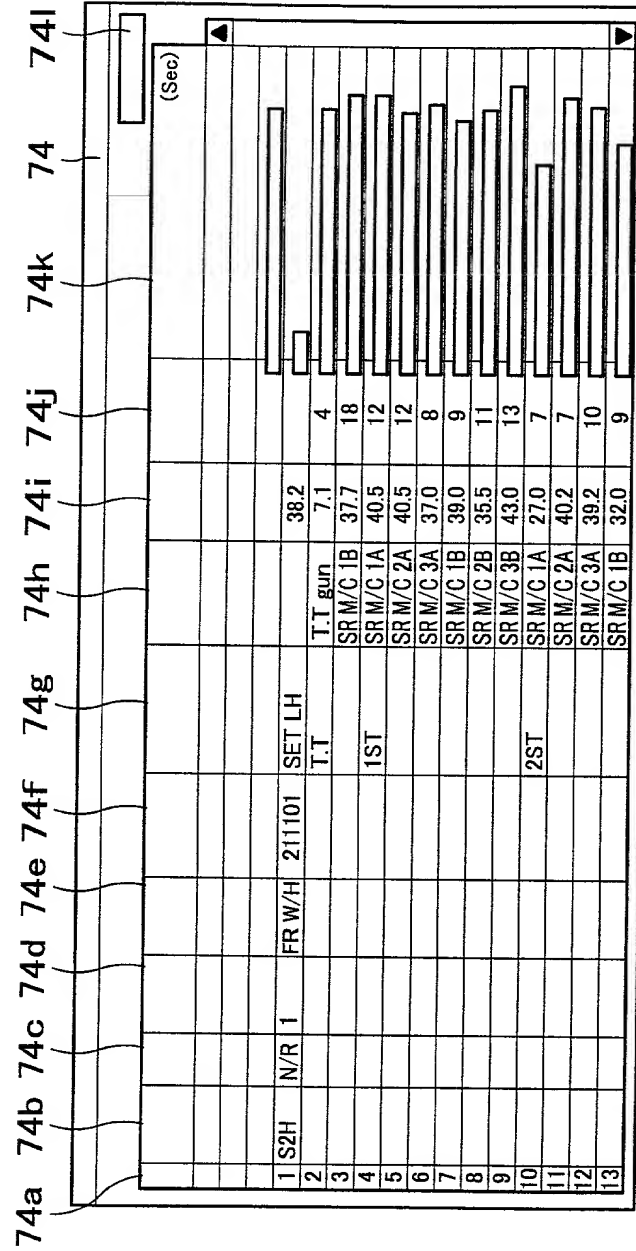


FIG.38



75a 75b 75c 75d 75e 75f 75g 75h 75i 75j 75k 75l 75m 75n 75o 75p

75r1 75r1

FIG. 40

FIG. 40

76a	76b	76c	76d	76e	76f	76g	76h	76i	76j	76k	76l	76m	76
SPEC													
1	S2H	N/R	1	FRW/H	211101	T.T	T.T gun	Set	4				
2							SR M/C 1B	Set	18				
3						1ST	SR M/C 1A	Set	12				
4							SR M/C 2A	Set	12				
5							SR M/C 3A	Set	8				
6							SR M/C 1B	Set	9				
7							SR M/C 2B	Set	11				
8							SR M/C 3B	Set	13				
9						2ST	SR M/C 1A	Set	7				
10							SR M/C 2A	Set	7				
11							SR M/C 3A	Set	10				
12							SR M/C 1B	Set	9				
13							SR M/C 2B	Set	14				
14							SR M/C 3B	Set	12				
15						Sub Total			146				
16													

76n

[illegible][illegible]

FIG. 42A

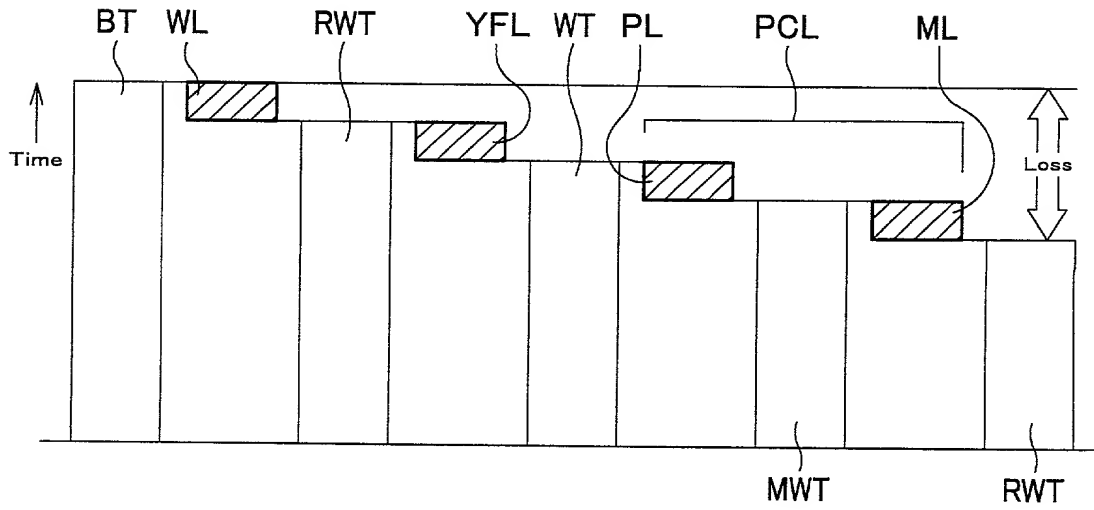


FIG. 42B

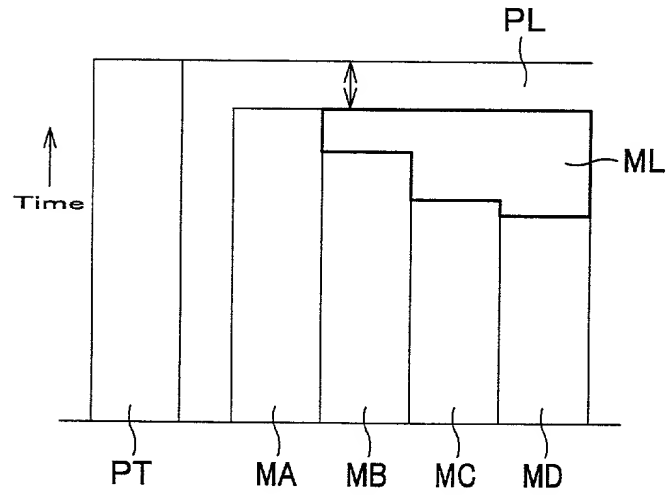


FIG. 43

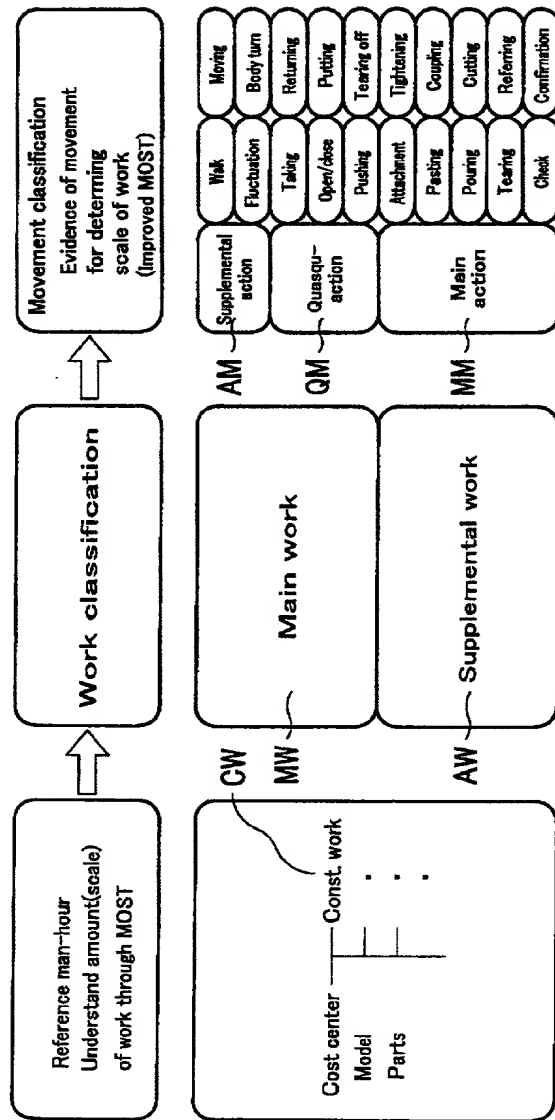


FIG.44

